

Work Order ID 59593

Tuesday, June 08, 2010 2:31:35 PM



Page 1

Item ID: D3537-1

Accept



Setup

Start



Revision ID:

Item Name: Wearpad

Start Date: 6/8/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *M*

Date: 10-6-08

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

0.00

10-6-08

FLOW CNC Waterjet

*304 .063*1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-6-08

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Counted

x46

Quality Control

S. w. b. b. 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 6/8/2010 Start Qty: 40.00

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Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID



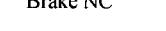
Operation
Description

130



NC BRAKE

Brake NC



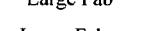
Brake NC

140



Large Fab

Large Fab



Large Fab



150



QC10- Inspect visual per QSI004- ground welds

Quality Control

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Run

Start



Stop



Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

46

SB bpb6/b3

R

10-6-29

X46

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat

M 114460 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any
weld that penetrated through Wearpadif necessary

0.00

0.00

8/06/29

46

W/O:		WORK ORDER CHANGES						
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Page 3

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Item Name: Wearpad

Start Date: 6/8/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run

Start



Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Swobels9

+46

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

Memo

0.00

START TIME:

9:15

OVEN TEMPERATURE:

3200

9:45

46 BK 10-7-7.

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 10/07/07

X46 P

W/O:		WORK ORDER CHANGES						
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, June 08, 2010 2:31:35 PM



Page 4

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Accept



Setup

Start



Stop



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Start Date: 6/8/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/21/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: FP-17Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

146

BL 10-7-7.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 2:31:38 PM

Page 1

Work Order ID: 59593



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 6/8/2010

Required Date: 6/21/2010

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.0000	0.106	4.463158	4.9		

304/316 Sheet .063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	128	
111323	0	
114799	128	114799

(46)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59593
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>PB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-6-22	Date:	10/06/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	✓ <i>[Signature]</i>

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

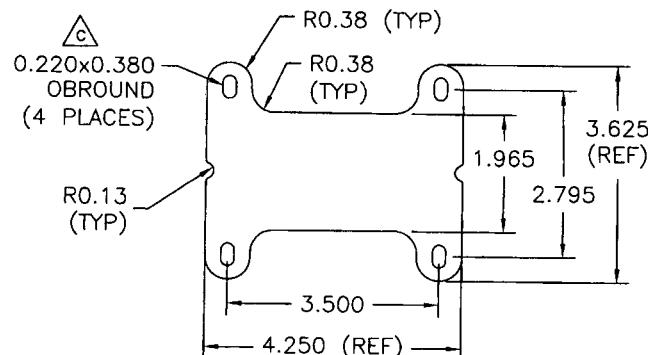
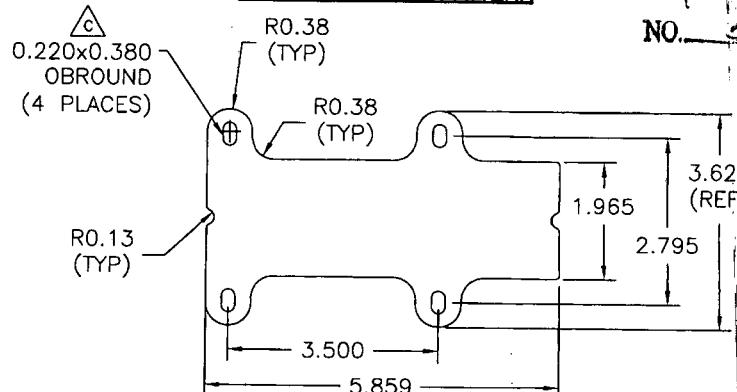
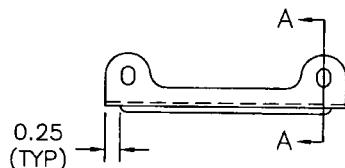
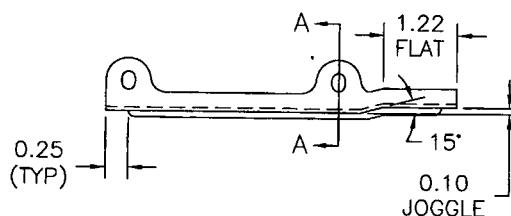
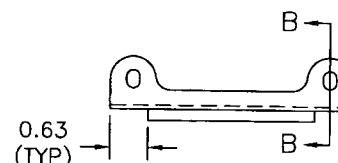
SHEET NO. 1 OF 1 AMENDMENT

V. 1.0 EDITION

V. 1.0 CADVER

NO. 59593

P/N-6-06

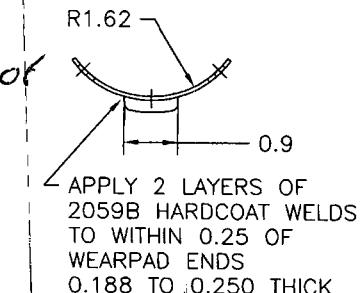
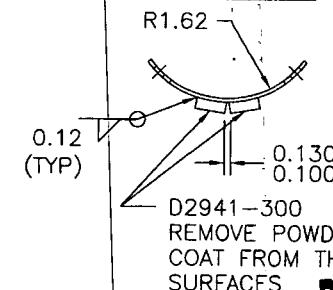
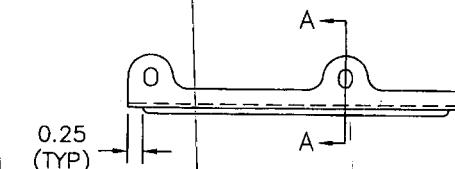
D3537-1F FLAT PATTERND3537-3F FLAT PATTERND3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C SHEET 1 OF 1
07.04.13		SCALE WEARPAD

SECTION A-ASECTION B-BRELEASED
07.05.08 PH
per E&L
962D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)

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